

WORK ORDER 2008-03

Date opened: 6 February 2008

Project: Quick Release Cargo Basket Assembly
Type: Eurocopter AS350/355 Series

Batch Quantity: 1 Complete Basket Assembly (77610-02)

Approval: Pending 5/10/08-16
Drawing List: DCL776-3

| Fabrication and Assembly Drawing(s) | Description |
|-------------------------------------|----------------------|
| 77610, Rev. 0 | Basket Ass'y |
| 77611, Rev. 0 | Basket Body Ass'y |
| 77612, Rev. 0 | Basket Lid Ass'y |
| 36255, Rev. 1 | Handle Installation |
| 36261, Rev. 4 | Handle Bar Ass'y |
| 36262, Rev. 1 | Handle Bracket Ass'y |

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

| | |
|---|------------|
| Project is on Approval Limitation Record: | <u>Y</u> ✓ |
| Document Control List revision level matches (or exceeds) STC: | <u>Y</u> ✓ |
| Drawings revision levels match Document Control List: | <u>Y</u> ✓ |
| Purchase order or Work order source is recorded for each part/ass'y: | <u>Y</u> ✓ |
| Tests and inspections specifically called out on drawings are complete: | <u>Y</u> ✓ |
| Release tags associated with all fabricated parts are attached: | <u>Y</u> ✓ |
| All mounting hardware and supplies are included: | <u>Y</u> ✓ |

List all non-conformities raised: _____

Jeff Clarke
Inspector Signature: _____

April 11/08
Date: _____

Drawing: 77610 Revision 0
 Assembly: 77610-02 Cargo Basket Ass'y (Quick-Release, Short, 61.25" long)

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|-------------|-------------------------|-------------------------------|-----------|---------|
| 1 Total | 77610-02 | Cargo Basket Assembly | | | |
| 1 | 77611-02 | Basket Body Assembly | Below | | |
| 1 | 77612-02 | Basket Lid Assembly | Below | | |
| 1 | 36255-01 | Handle Bar Installation | Below | | |
| 1 | 36280-01 | Brace Assembly | 9-2081 Brace | 7005 | |
| 1 | MS20001P4 | Piano Hinge | | 7038 | |
| 1 | 77628-01 | Placard | 0.063 Sheet, 6061-T6 Aluminum | 960708 | |
| 3 | 49205-14 | Bumper | Argus Industries Bumper | 6038 | |
| A/R | CR3213-4-02 | Cherry Rivet | | 8020 | |
| 4 | 40088-14 | Fitting | Ancra | 6058 | |
| 4 | AN960-616 | Washer | | 6016 | |
| 1 | AN3-15A | Bolt | | 6016 | |
| 1 | AN3-17A | Bolt | | 6066 | |
| 4 | AN960-10 | Washer | | 6043 | |
| 2 | AN970-3 | Washer | | 5026 | |
| 2 | MS21044N3 | Nut | | 6016 | |

| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|--------------------|------------|-----------|
| Riveting | AC43.13-1B | CR3213-4-02 Rivets | | gc. |
| Final Inspection | Drawing 77610 | | | gc. |

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 77611 Revision 0
 Assembly: 77611-02 Basket Body Ass'y (Quick-Release, Short, 61.25" long)

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|----------|-------------------------|------------------------------------|-----------|---------|
| 1 Total | 77611-02 | Basket Body Assembly | | | |
| 2 | 76421-01 | Hoop | 4130 Steel, 1/2" x 0.035 Sqr. Tube | 8007 | |
| 2 | 76422-01 | Attachment Hoop | 4130 Steel, 1/2" x 0.035 Sqr. Tube | 8007 | |
| A/R | | Tube | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 8007 | |
| A/R | | Tube | 4130 Steel, 1/2" x 0.035 Sqr. Tube | 8007 | |
| 1 | 36262-01 | Handle Bracket Assembly | Below | | |
| 1 | 49215-01 | Spacer | 1018 Steel, 1/2" Rod | 951108 | |
| A/R | 3/4-16F | Mesh | Expanded carbon steel | 7029 | |

| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|---------------------|------------|------------|
| Welding | AMS 2685C | Welding Rod ER70S-2 | | <i>JK</i> |
| Powder Coat | Drawing 77611 | | | <i>JK</i> |
| Final Inspection | Drawing 77611 | | | <i>JK.</i> |

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 77612 Revision 0
Assembly: 77612-01 Basket Lid Ass'y (Quick-Release, Short, 61.25" long)

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|----------|-------------------------------|------------------------------------|-----------|---------|
| 1 Total | 77612-02 | Basket Lid Assembly | | | |
| A/R | | Tube | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 8007 | |
| 1 | 49216-01 | Spacer | 1018 Steel, 1/2" Rod | 951108 | |
| 1 | 36262-01 | Upper Handle Bracket Assembly | Below | | |
| 1 | 36204-10 | Placard Bracket | 1018 Steel, 0.035" Sheet | 9516042 | |
| A/R | 3/4-16F | Mesh | Expanded carbon steel | 7029 | |

| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|---------------------|------------|-----------|
| Welding | AMS 2685C | Welding Rod ER70S-2 | | JP |
| Powder Coat | Drawing 77612 | | | gc. |
| Final Inspection | Drawing 77612 | | | gc. |

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|-----------|--------------------------|-------------------------------------|-----------|---------|
| 1 Total | 36255-01 | Handle Installation | | | |
| 1 | 36261-01 | Handle Bar Assembly | Below | | |
| 2 | 36278-01 | Spring (1 left, 1 right) | 304 Stainless, 1/16" Dia Music Wire | 7004 | |
| 2 | 36275-01 | Bushing | SAE 660 Bronze, 5/16" Dia | 6068 | |
| 2 | AN3-14A | Bolt | | 6071 | |
| 4 | AN960-10 | Washer | | 6043 | |
| 2 | MS21044N3 | Nut | | 6016 | |

| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|-------------|------------|-----------|
| Final Inspection | Drawing 36255 | | | jc. |

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 36261 Revision 4
Assembly: 36261-01 Handle Bar Assembly

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|-------------|---------------------|--|-----------|---------|
| 1 Total | 36261-01 | Handle Bar Assembly | | | |
| 1 | 36277-01 | Handle Bar | 316 Stainless, 1.0 x 0.035 Rnd. Tube | 6006 | |
| 2 | 36271-01 | Lever | 304 Stainless, 0.105 Sheet | 7006 | |
| 2 | 36274-01 | Bushing | 304 Stainless, 7/16" x 0.065 Rnd. Tube | 2005 | |
| 2 | MS20615-4M3 | Rivet | | 7039 | |



| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|--------------------|------------|-----------|
| Welding | AMS 2685C | Welding Rod ER308L | | AP |
| Final Inspection | Drawing 36261 | | | gc. |

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

| Qty Per | Part # | Description | Material | P.O./W.O. | Checked |
|---------|----------|-------------------------|----------------------------|-----------|---------|
| 1 Total | 36261-01 | Handle Bracket Assembly | | | |
| 1 | 36272-01 | Basket Bracket | 321 Stainless, 0.050 Sheet | 3021 | |
| 2 | 36273-01 | Lid Bracket | 321 Stainless, 0.050 Sheet | 3021 | |
| 2 | 36275-02 | Support | 304 Stainless, 5/16" Rod | 6003 | |

| Processes | Per | Mat'ls Used | Inspection | Signature |
|------------------|---------------|--------------------|------------|---|
| Welding | AMS 2685C | Welding Rod ER308L | |  |
| Final Inspection | Drawing 36262 | | |  |

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (Short) Part #: 77610-02

Approval #: SH08-16 Serial #: 77602-01

WO #: 2008-03 Quantity: 1

Eligibility: Eurocopter AS350 / AS355 Series Work Status: Manufactured

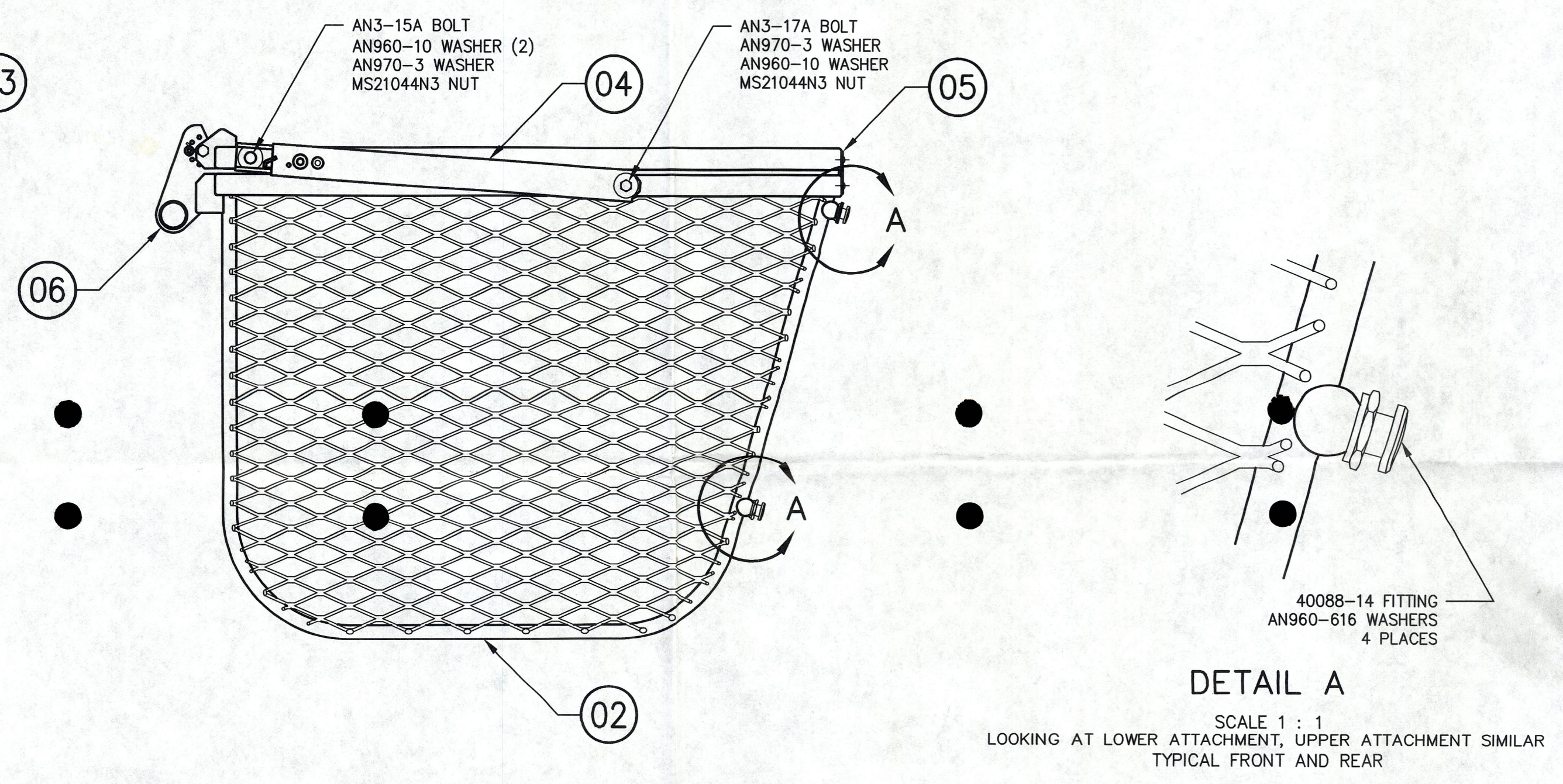
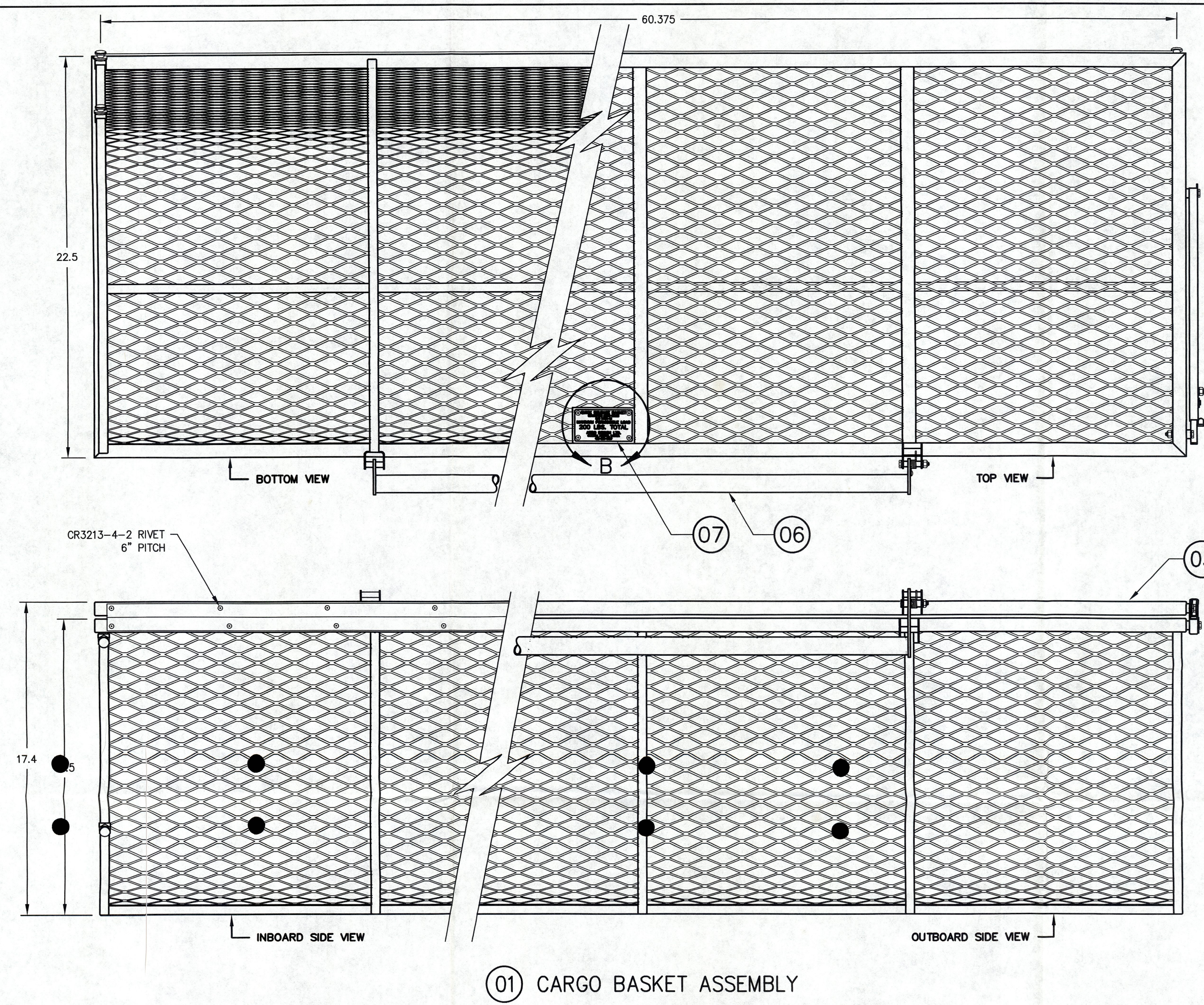
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

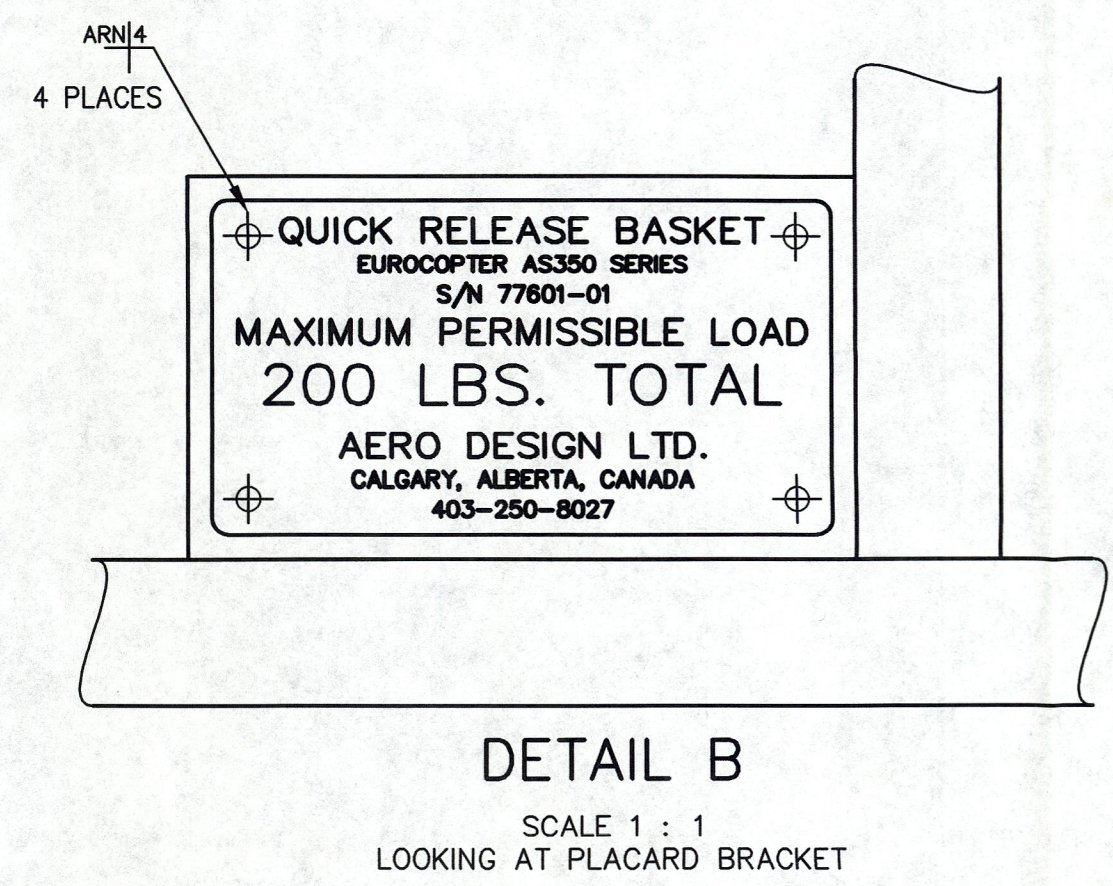
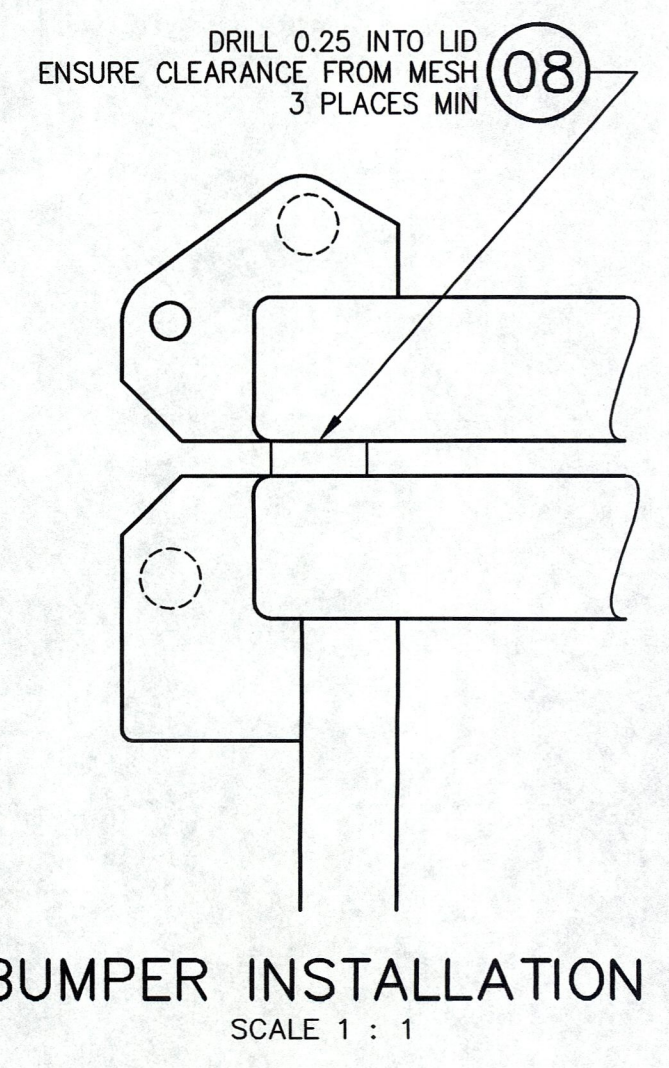
April 11/08
Date

[Signature]
Inspector's Signature

| | | | |
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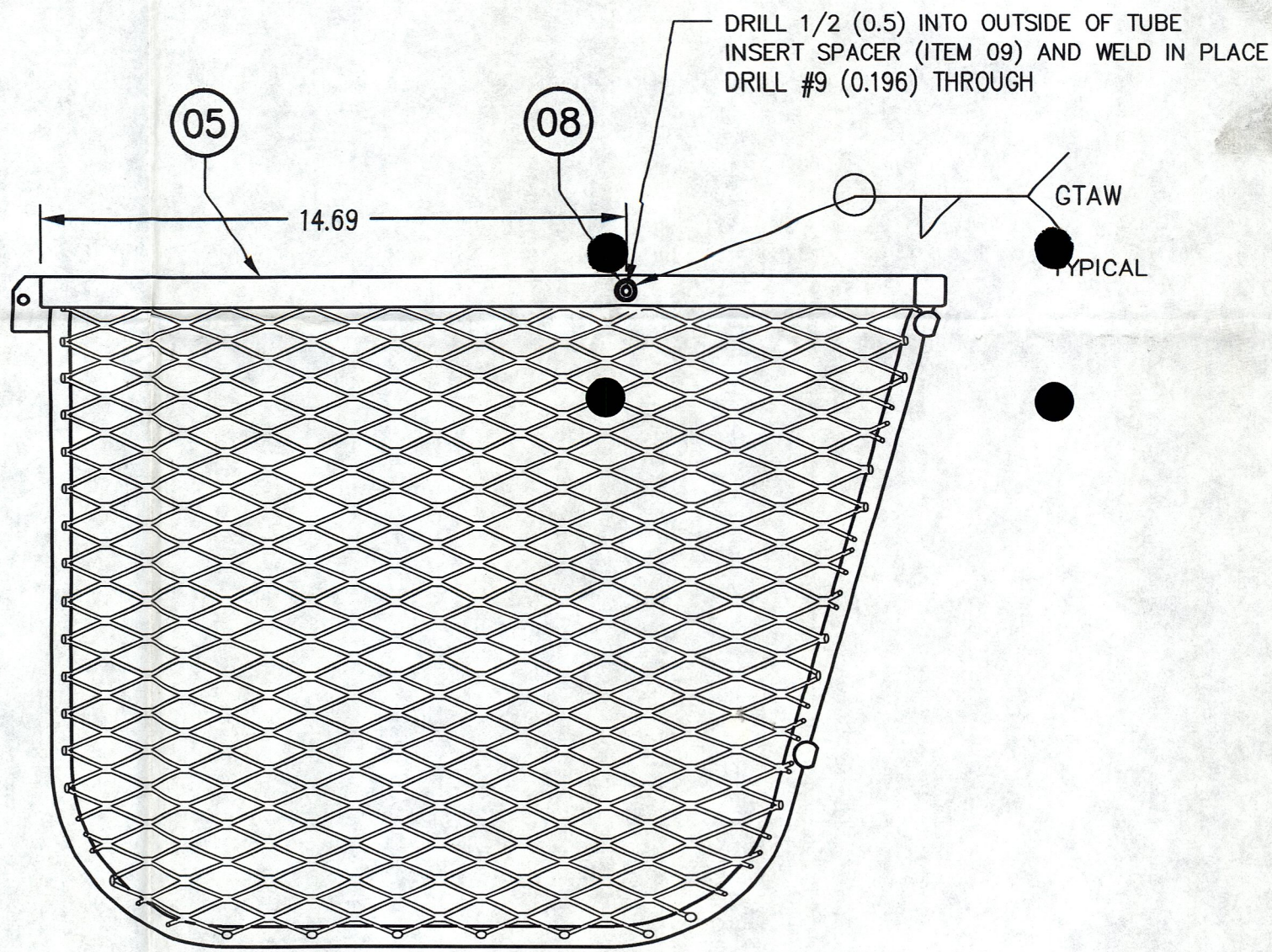
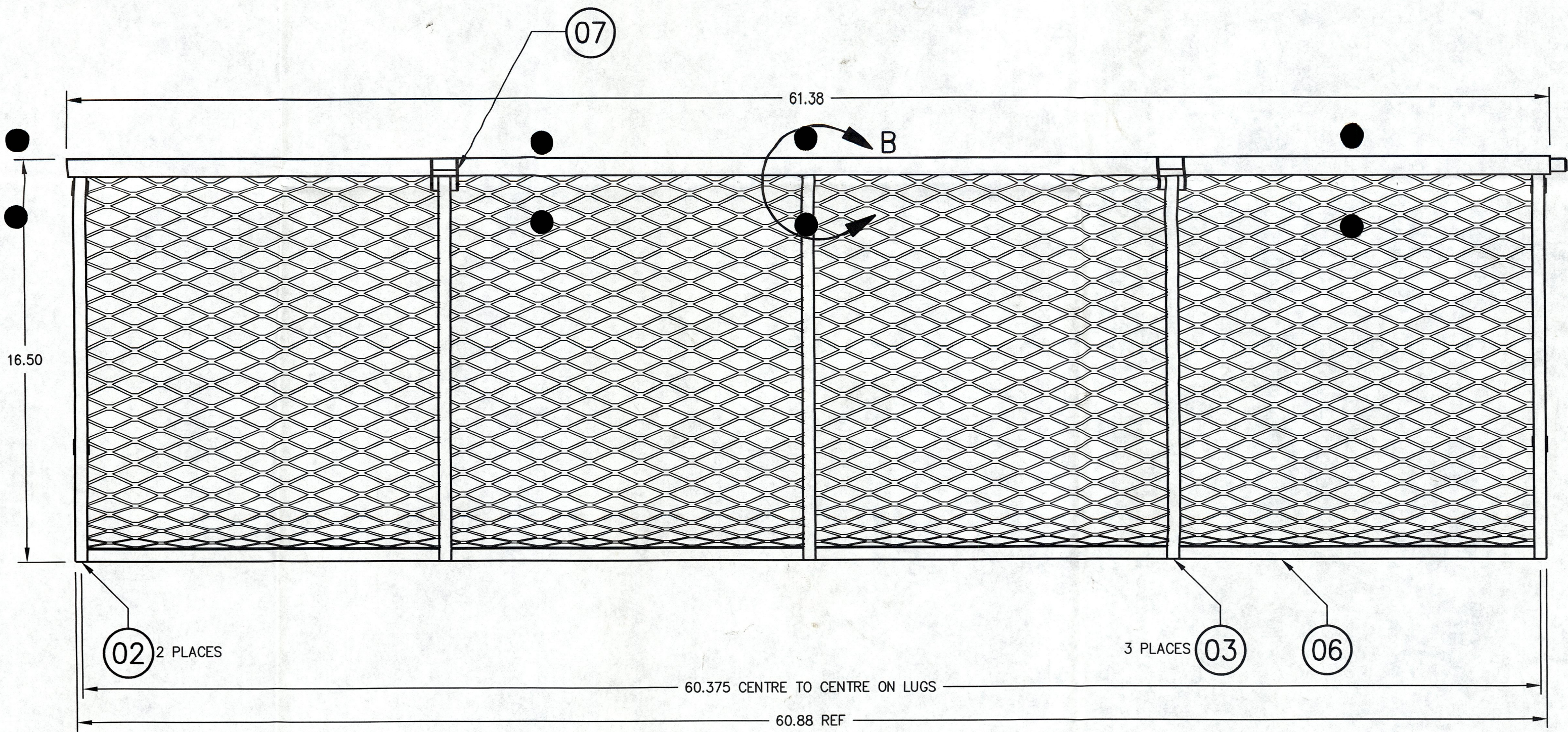
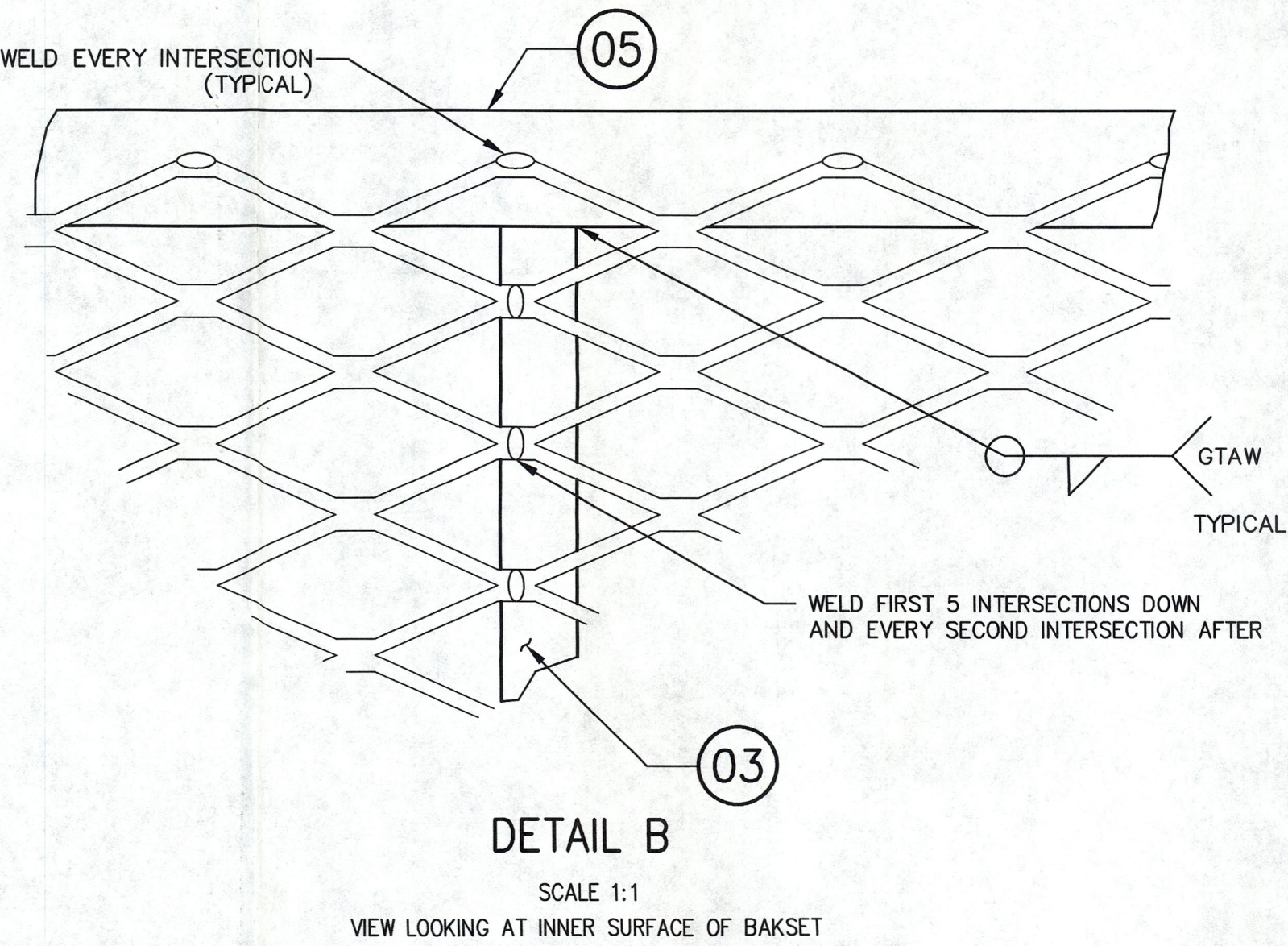
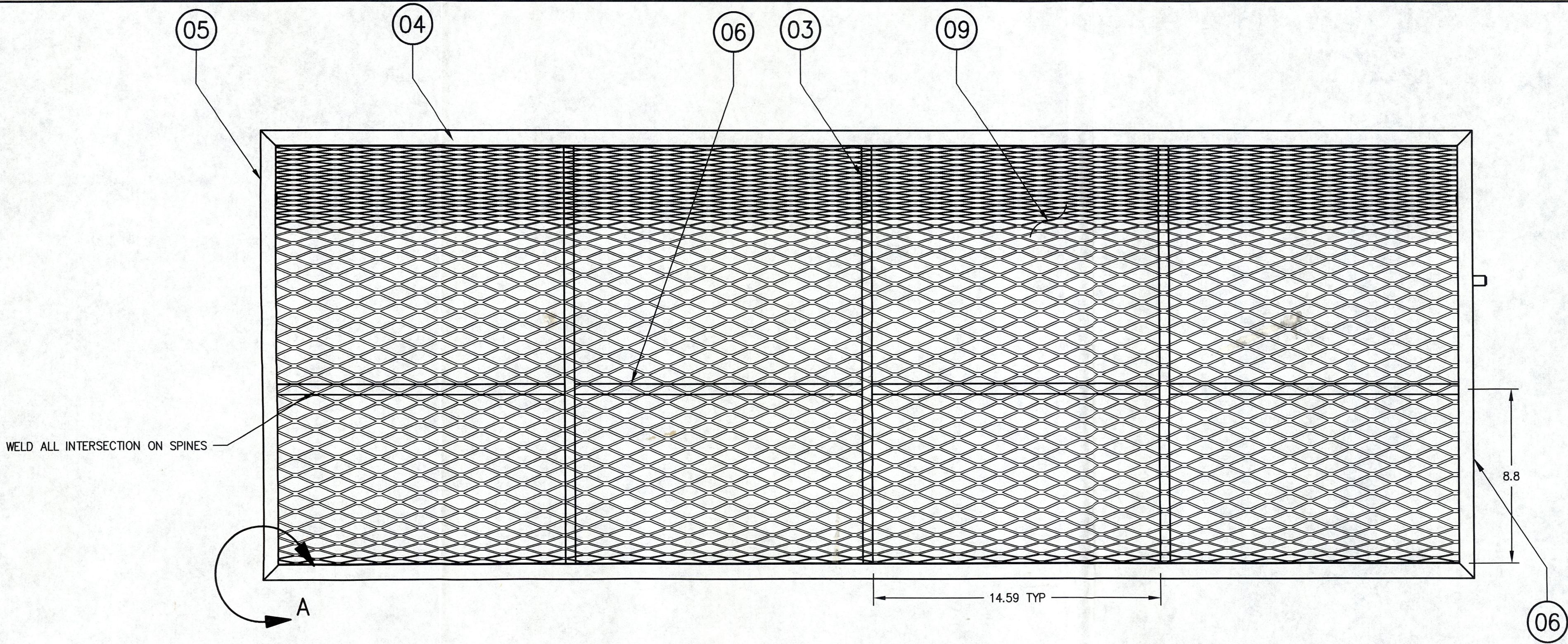
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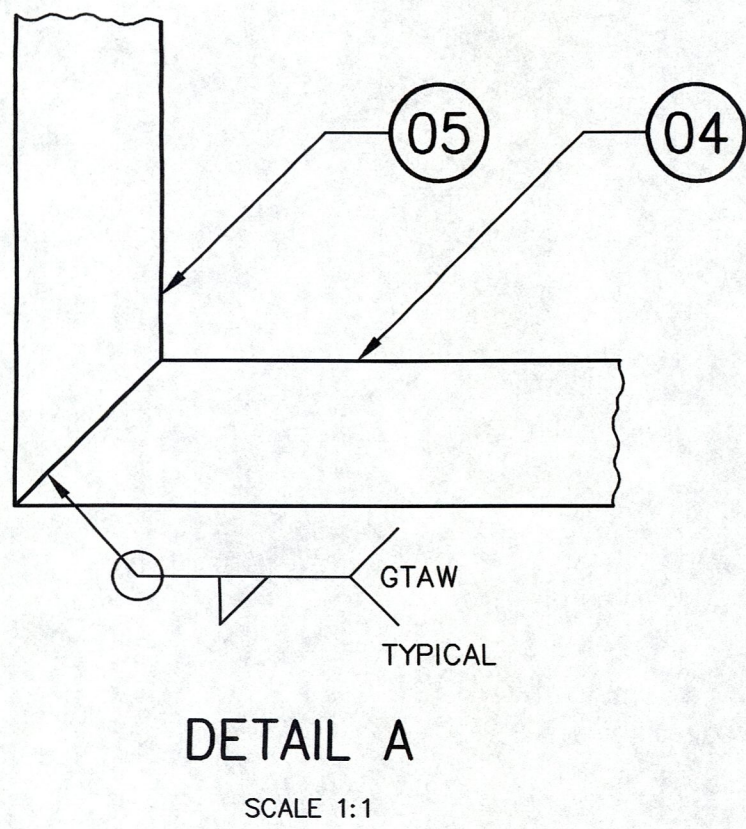
| | | | | | |
|-----|-------------------|----------------------------|------------------|----------|--------------------------|
| A/R | AN960-616 | WASHER | | | |
| 4 | 40088-14 | FITTING | ANCRA | | |
| A/R | CR3213-4-02 | CHERRY RIVET | | | |
| 3 | 49205-14 | 08 BUMPER | ARGUS INDUSTRIES | | |
| 1 | 77627-01 | 07 PLACARD | | | |
| 1 | 36255-01 | 06 HANDLE BAR INSTALLATION | | | |
| 1 | MS20001P4 | 05 PIANO HINGE | | | 6 FEET LONG |
| 1 | 36280-01 | 04 BRACE ASSEMBLY | | | |
| 1 | 77612-01 | 03 LID ASSEMBLY | | | |
| 1 | 77611-01 | 02 BASKET BODY ASSEMBLY | | | |
| 1 | 77610-01 | 01 CARGO BASKET ASSEMBLY | | | |
| 01 | PART NO. | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC STOCK SIZE |
| QTY | LIST OF MATERIALS | | | | |

| | | | | | | | |
|---|--|--------------------|--------------|---|----------|------|--|
| BASIC CODE REF. NAS 523 C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARM=CR3212 | DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE | APPROVALS | DATE | AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca | | | |
| | DASH NO. FOR LENGTH | DRAWN: JEFF CLARKE | 30 NOV 2007 | EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET BASKET ASSEMBLY | | | |
| | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1 | CHECKED: E. BURGON | SCALE 1 : 4 | | | | |
| | | | SHEET 1 OF 1 | | | | |
| | | | | DWG. SIZE | DWG. NO. | REV. | |
| | | | | A1 | 77610 | 0 | |

| | | | |
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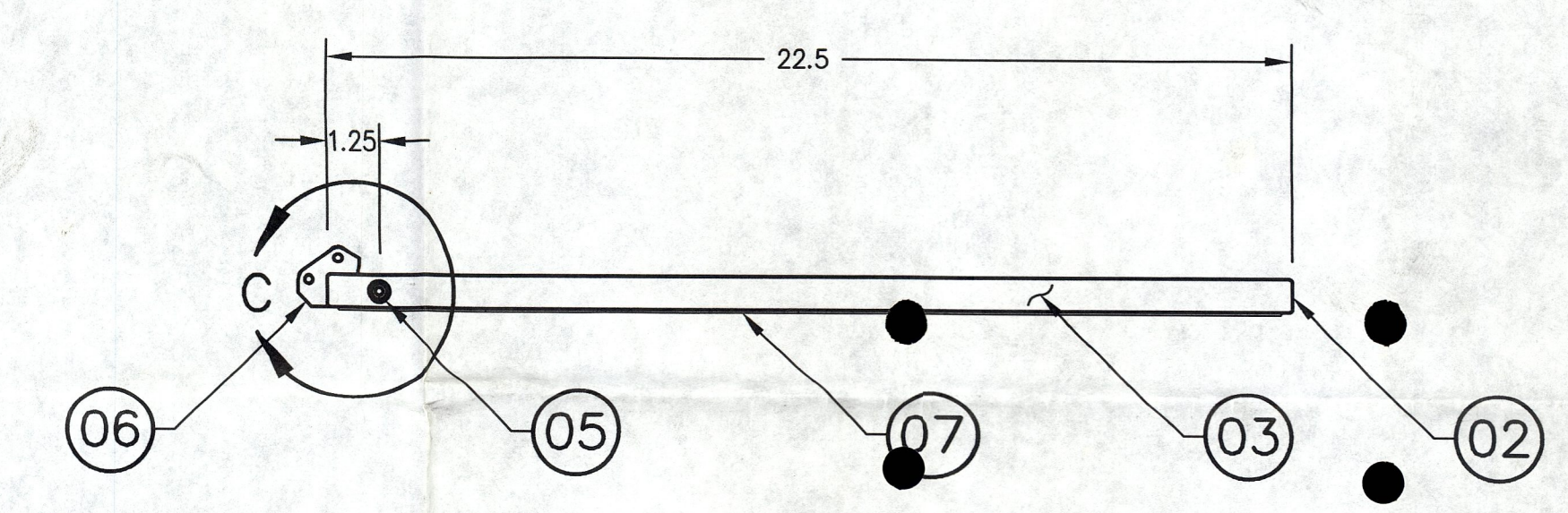
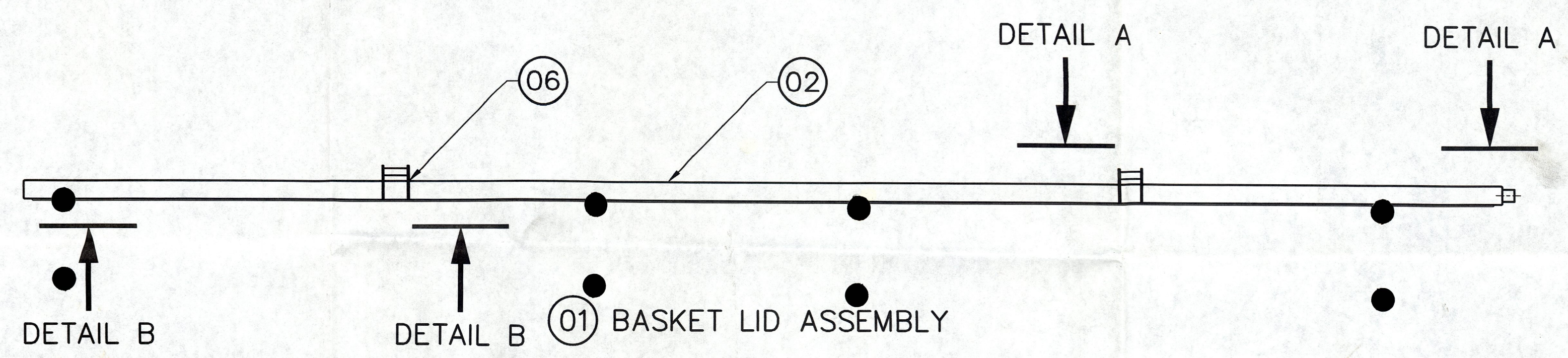
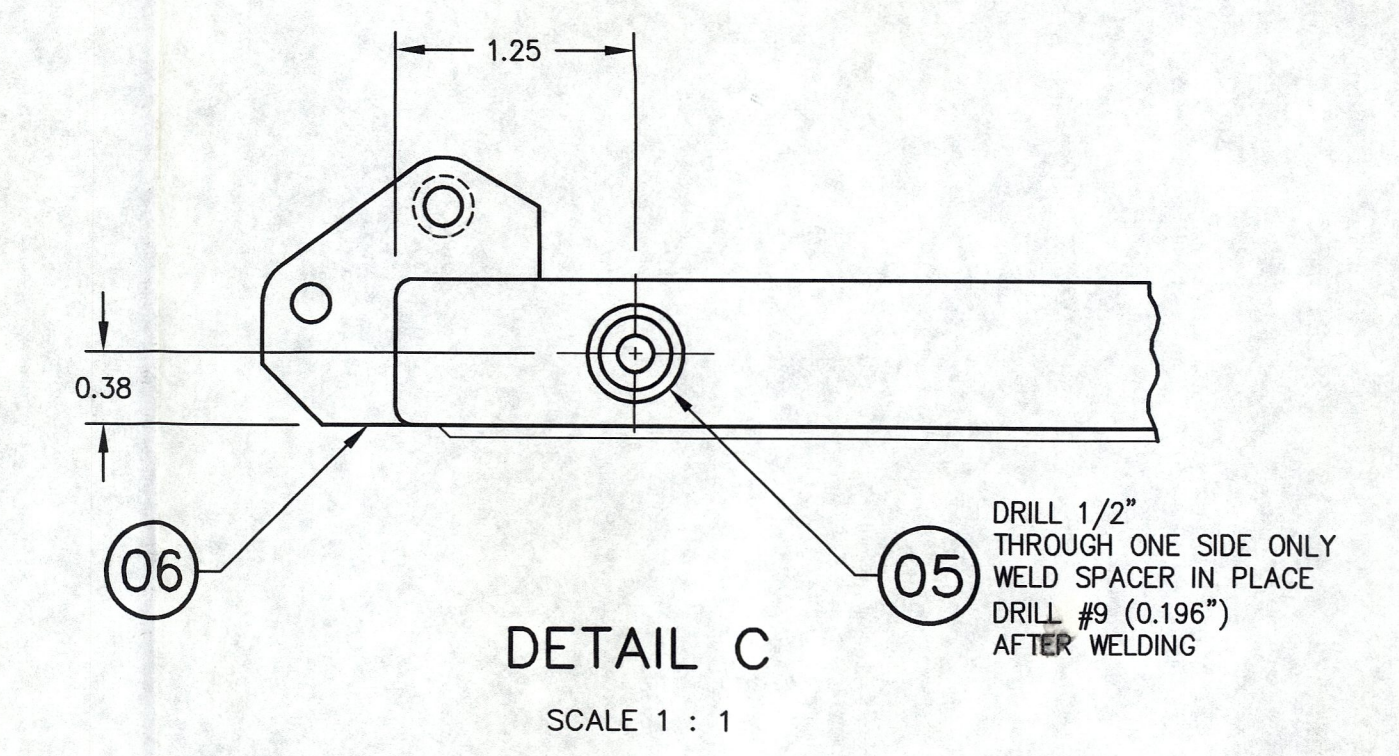
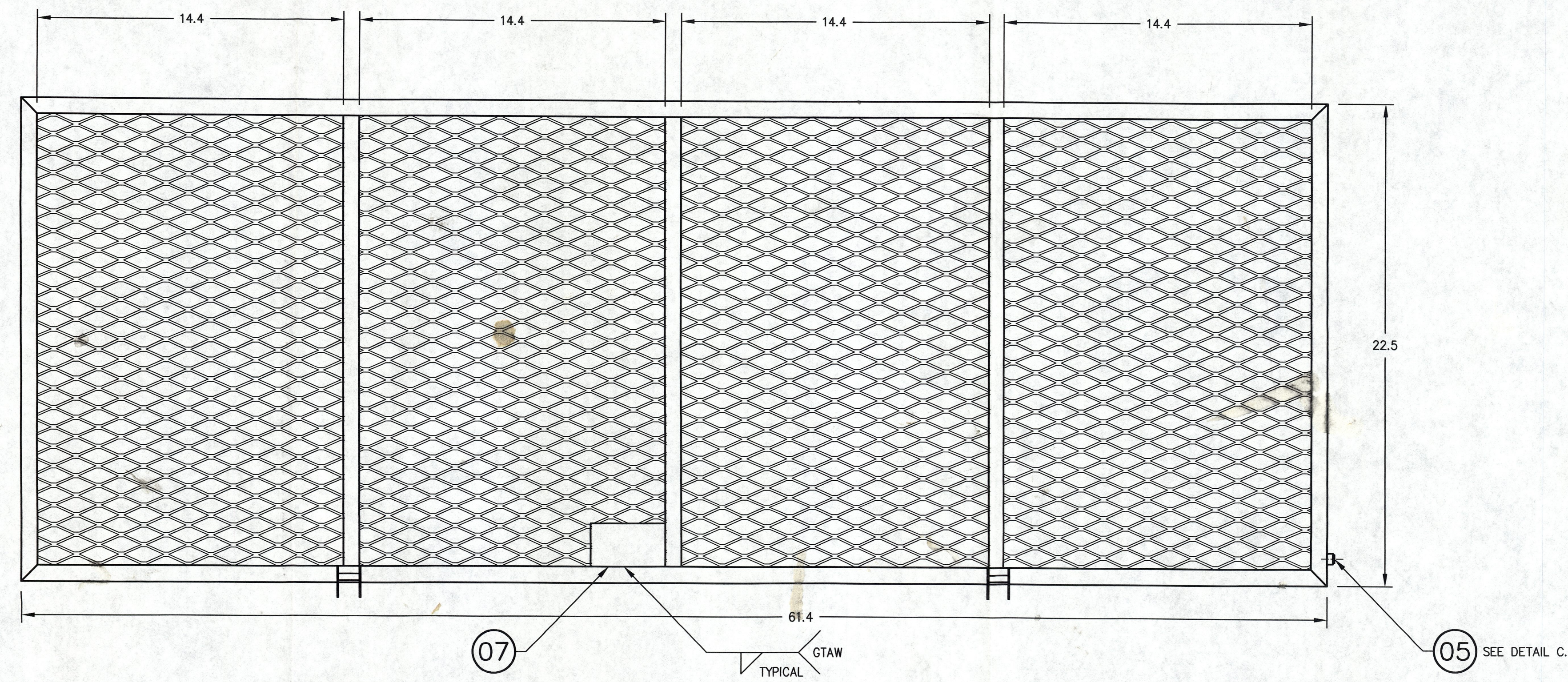
01 BASKET BODY ASSEMBLY



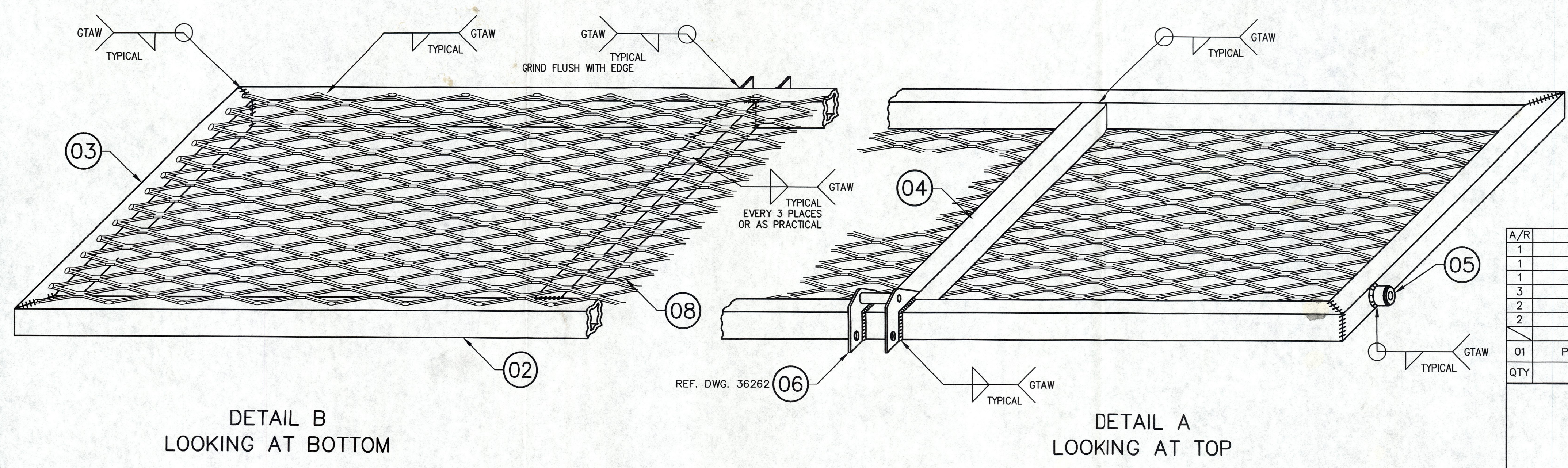
- NOTES:
1. FASTEN MESH TO BASKET AFTER ASSEMBLY OF BASKET. MESH TO BE ATTACHED TO THE INNER SURFACE OF THE BARREL OF THE BASKET. MESH COVERING THE ENDS TO BE BENT INWARD AT EDGES AND WELDED TO INNER EDGE OF THE END HOOP.
 2. REMOVE ALL BURRS AND SHARP EDGES.
 3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO AMS 64/A.
 4. THOROUGHLY DEGREASE ALL PARTS, PRIME, AND PAINT WHITE.

| | | | | | | |
|-----|-------------------|--|-------------------------|---|---------------|------------|
| A/R | 3/4-16F | 09 | MESH | STEEL | COMMERCIAL | |
| 1 | 49215-01 | 08 | SPACER | | | |
| 1 | 36262-01 | 07 | HANDLE BRACKET ASSEMBLY | | | |
| 4 | 77625-01 | 06 | SPINE | | | |
| 2 | 49212-01 | 05 | RIM | | | |
| 2 | 77624-01 | 04 | RIM | | | |
| 3 | 50510-01 | 03 | HOOP | | | |
| 2 | 77621-01 | 02 | ATTACHMENT HOOP | | | |
| | 77611-01 | 01 | BASKET BODY ASSEMBLY | | | |
| 01 | PART NO. | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE |
| QTY | LIST OF MATERIALS | | | | | |
| | | APPROVALS | DATE | <div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net</div> | | |
| | | DRAWN: JEFF CLARKE | 30 NOV 2007 | | | |
| | | CHECKED: E. BURGAIN | | | | |
| | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2* X.XX ±0.03 X.X ±0.1 | | EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY | | |
| | | SCALE 1 : 4 | DWG. SIZE | DWG. NO. | REV. | |
| | | SHEET 1 OF 1 | A1 | 77611 | 0 | |

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| REV. | DESCRIPTION OF CHANGE | INITIALS | DATE |
| 0 | * | * | * |



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



| | | | | | | | | | | |
|--|-------------------|------|---------------------------|---|---------------|------------|----------|--|------|--|
| A/R | 3/4-16F | 08 | MESH | | | | | | | |
| 1 | 36204-10 | 07 | PLACARD BRACKET | | | | | | | |
| 1 | 36262-01 | 06 | UPPER HANDLE BRACKET ASSY | | | | | | | |
| 1 | 49216-01 | 05 | SPACER | | | | | | | |
| 3 | 49213-01 | 04 | LID BRACE | | | | | | | |
| 2 | 49212-01 | 03 | RIM | | | | | | | |
| 2 | 77624-01 | 02 | RIM | | | | | | | |
| | 77612-01 | 01 | BASKET LID ASSEMBLY | | | | | | | |
| Q1 | PART NO. | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE | | | | |
| QTY | LIST OF MATERIALS | | | | | | | | | |
| <div>APPROVALS</div> <div>DATE</div> <div>DRAWN: JEFF CLARKE</div> <div>CHECKED: E. BURGOIN</div> <div>30 NOV 2007</div> <div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</div> <div>DECIMALS ANGLES</div> <div>X.XXX ±0.010 ±1/2"</div> <div>X.XX ±0.03</div> <div>X.X ±0.1</div> | | | | <div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M</div> <div>2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7</div> <div>tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net</div> | | | | | | |
| | | | | <div>EUROCOPTER AS350 SERIES</div> <div>QUICK RELEASE CARGO BASKET</div> <div>BASKET LID ASSEMBLY</div> | | | | | | |
| | | | | SCALE 1 : 4 | | DWG. SIZE | DWG. NO. | | REV. | |
| | | | | SHEET 1 OF 1 | | A1 | 77612 | | 0 | |

E:\7_jobs\77612_0.dwg Mon Dec 03 09:24:16 2007